

Work Order ID 55959

February 8, 2010 11:40:35 AM



Page 1

Item ID: D4055-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Upper Cut Out

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *U*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

PAT

Rev. A E

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: *11330*
Purchase part as per Dwg D4055
Possible Supplier: GFI
Material release note required

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

120

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Memo

0.00

8/6/2010 to Prem Day only

*Parts have change from PAT to RWA
Day. no long confirm.
Parts must be RWA*

8/10/22

QC APPROVAL

PRELIMINARY ISSUE

NIA
P/O -> Last
Page
PS 10-2-08
(3)

6/14/3/4

Work Order ID 55959

February 8, 2010 11:40:35 AM



Page 2

Item ID: D4055-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Upper Cut Out

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

N/A

E 10.03.10

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

E 10.03.10

3

Work Order ID 55959

February 8, 2010 11:40:36 AM

Page 3

Item ID: D4055-5

Accept

Revision ID:

Item Name: Tank Upper Cut Out

Start Date: 2/08/10 Start Qty: 3.00

Required Date: 2/22/10 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

100708

61003-11

bless

POSITIVE RECALL

EFFECTIVE 10/20/08 AUTH h

RELEASED 7 DATE 10/24/06 Qty 3.

Picklist Print

February 8, 2010 11:40:33 AM

Page 1

Work Order ID: 55959



Parent Item: D4055-5



Parent Item Name: Tank Upper Cut Out

Start Date: 2/08/10

Required Date: 2/22/10

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4055-5P		Purchased	No			110	Each	0.0000	3.0000			

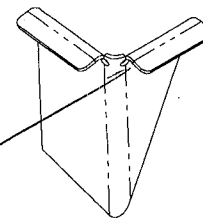
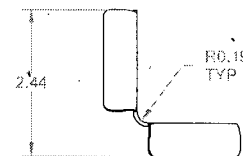
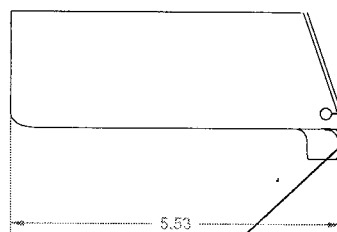
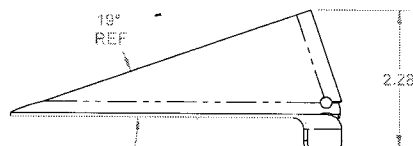


Tank Upper Cut Out



100706. (K3)

WLO
55959



See Rev. A

D4055-5 UPPER CUT OUT

PRELIMINARY ISSUE

10.01.11

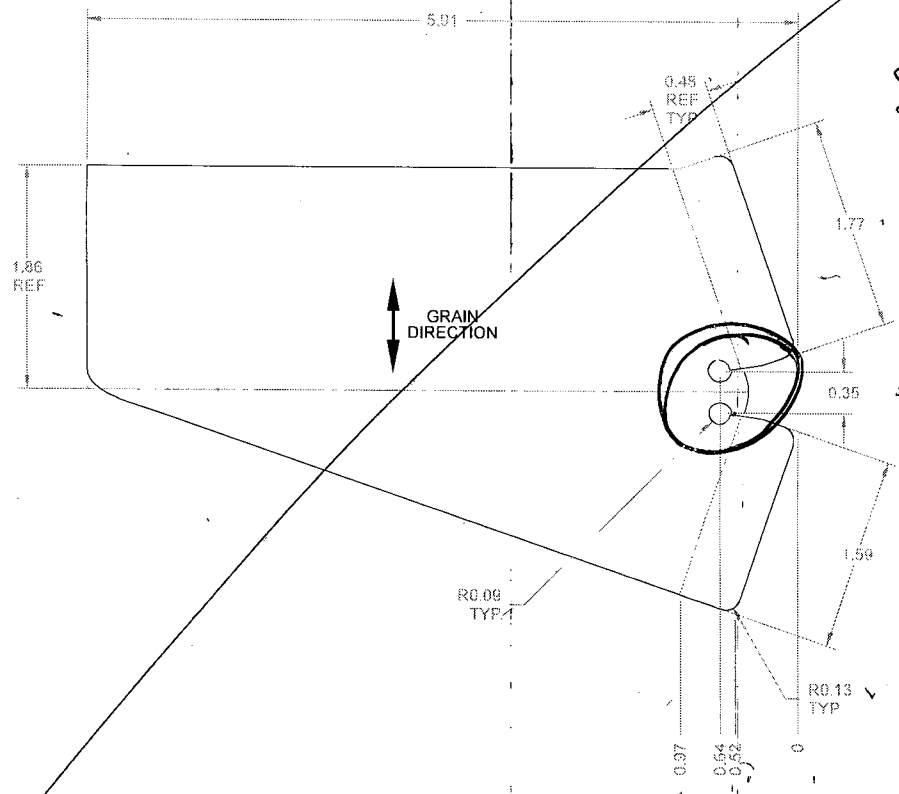
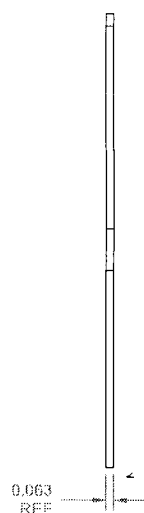
NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4055	SHEET 8 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.01.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

1055959

See Rev A



D4055-5F FLAT PATTERN

PRELIMINARY ISSUE

10.01.11

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4055	SHEET 9 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.01.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11330

Purchase Order Date 2/08/10

PO Print Date 2/08/10

Page Number 1 of 2

Order From :
GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

VC-GFI001

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 630 4877	Requisition Nbr	
Vendor Fax	514 630 4849	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4055-3P	Tank Aft End	3/04/10 Yes	3.00 Each	Purolator ground	\$115.0000	\$345.0
Special Inst: As per DWG 4055 B#55957							
2	D4055-5P	Tank Upper Cut Out	3/04/10 Yes	3.00 Each	Purolator ground	\$115.0000	\$345.0
Special Inst: AS PER DWG D4055 B#55959							
3	D4055-7P	Tank Fwd End	3/04/10 Yes	3.00 Each	Purolator ground	\$115.0000	\$345.0
Special Inst: AS PER DWG D4055 B#55960							
4	D4055-9P	Tank Back	3/04/10 Yes	3.00 Each	Purolator ground	\$115.0000	\$345.0

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 2/08/10



180 AVENUE LABROSSE
POINT-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
JR - DY	MO. - MO.	AN. - YR		
02	03	10	0433552	1/1

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VE:NDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA		
DART	GFI-0299	PO11330			
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.	DESCRIPTION			
3	D4055-5P	TANK UPPER CUT OUT			
		CERTIFICATE OF CONFORMANCE REQ			
MFG. JOB# J02010445-001 QTY 3					
(1) BOX					

REÇU PAR / RECEIVED BY

DATE

EXPÉDITEUR
SHIPPER

N° DE BON DE LIVRAISON
SHIPPING MEMO NO.

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

8
10/03/09

CERTIFICATE NO. 1 OUR JOB NO J0210445 SHIPPING MEMO 0433552

ITEM QUANTITY PURCHASE ORDER PART NUMBER REV NAME DWG ISSUE

-- 3 PCS PO11330 D4055-5P TANK UPPER CUT OUT PA1

MATERIAL

AL 6061-T6

SUPPLIED BY

SAMUEL / ALCOA INC

MAT. REL. NO.

608951

PROCESS

PROCESSOR

RELEASE NOTE #

1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0210445-001 (3 PCS)</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 MARCH 2010

G.F.I. Q.C. REP. Caltan





LES METAUX SPECIALISES SAMUEL
21525 CLARK-GRAHAM
BAIE D'URFE, QUEBEC, CANADA
H9X 3T5

No 001591859



(514) 457-3399 FAX(514) 457-9393

PAGE 1 DE/OF.1

TRANSPORTEUR/CARRIER NAME
ASTERO TRANSPORT

CAMION/TRUCK
099

NOM DE LA BRANCHE/SALES BRANCH NAME
SAMUEL & FILS & CIE(QUEBEC) L

DATED/EXP/DATE OF SHIPMENT
2/16/10

VENDU À/SOLD TO:

GFI, DIVISION DE THOMAS & BETTS LTEE
180 LABROSSE

EXPÉDIÉ À/SHIP TO: TÂB: PPD

GFI INC.
180 LABROSSE

POINTE-CLAIRE

QC

H9R1A1

(514) 630-4877

POINTE-CLAIRE

QC

H9R1A1

CA

(201009-00001)

N° COMMANDE
N° ITEM
000752-01

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 76423

Cert/Test: FAX

4 PCS AL. SH. 6061 T6

174 LVR

.0630"x48"x144"

QQA 250/11

#Pièce AS06348144QM

Description

Art

Pd ca

Qté

#Étiq

Vendeur Org

#Étiq mln

#À soul

4

192.000

174

Étq princ

#Coul

US

764479

4947487

ALR

Total:

4

192.000

174

D654824 608951

Poids total:

174 LVR

#Total paquets:

1

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ

LE MATÉRIEL DÉTAILLÉ CI-DESSUS EST CERTIFIÉ

CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX

SPÉCIFICATIONS DES NORMES DU GRADE. SVP VOUS

RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:

MÉLISSA DIAMOND
ADMINISTRATION

DATE 16/02/10



NIR: R-539477-1

PREL PAR <input checked="" type="checkbox"/> PORTPAYÉ/REPAID <input type="checkbox"/> BORDU/COLLECT	INST. VOITURIER/DRIVER INSTRUCTIONS	VALEUR (\$2000 max à moins d'avis contraire) VALUATION (Max \$2000 unless otherwise stated) VALUE DÉCLARÉE DE L'EXPÉDITION DECLARED VALUE OF SHIPMENT
EXPÉDITEUR/DISPATCHER	VOITURIER/DRIVER	REÇU PAR/RECEIVED BY

1. ORIGINAL - NON NÉGOCIABLE (CE CONNAISSEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

1058276 0
Ship Date B.L. No. Invoice No. Alcoa No. Item Page
2009-10-15 4303234 00000 1000143904-6 DCE-43904-6
P.O. No./Govt Contract No. Customer Alcoa Item
N22238 Ln#: 6 SAMUEL SON & CO LT G041110647R02

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125
-.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-
209 REV 07 EXC MRK ASTMB209 REV 07
CMMP025 REV S CMMP019 REV D ((MARKED))
KRAFT PAPER INTERLEAVED MAX GROSS
SKID WGT: 4500 LB QUAN TOL +/-30 %
CQR 0222751 REV 02 CUST REQ 09-10-
01 *** W/E 09-10-24 ***

8/10/09

2644344-3-4

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl	Inspector Clock Numbers
1	764477	608951	4119	100	PC		27299 47004
2	764478	608951	3408	83	PC		27299 47004
3	764479	608951	4149	100	PC		27299 47004
			11676	283			

Notes for CQR: 0222751.2
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0222751.2 -Specification Limits

Tmpr Dir	Long Transv.	Max	Min	UTS KSI	TYS KSI	EL4D PCT										
							SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total
				42.0	35.0	10	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
							0.40		0.15		0.8	0.04				

Chemical Composition

Alloy 6061

REMAIN

CERTIFIED INSPECTION REPORT

Alcoa Inc.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

PITTSBURGH, PA DAVENPORT WORKS
Ship From: RIVERDALE, IA.

1058276
Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

Page 2

2009-10-15

4303234

00000

1000143904-6

DCE-43904-6

P.O. No./Govt Contract No.

Customer

Alcoa Item

N22238 Ln#: 6

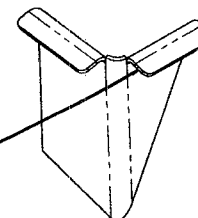
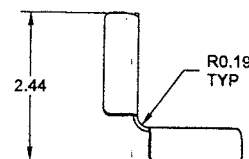
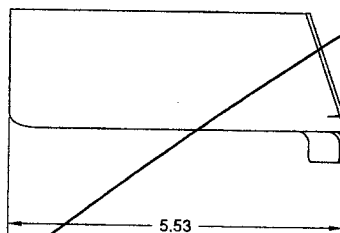
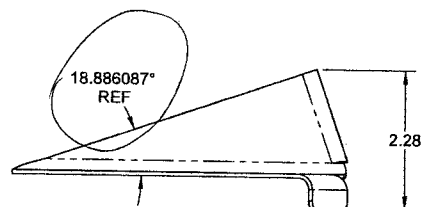
SAMUEL SON & CO LT G041110647R02

CQR: 0222751.2 -Specification Limits (cont.)
Lot: 608951 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
T6	Long Transv.	Test	KSI	KSI	PCT
		2	50	44.8	10.9
			49.9	44.8	10.9

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H8054013	Actuals	0.66	0.5	0.26	0.06	0.9	0.19	0.05	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States








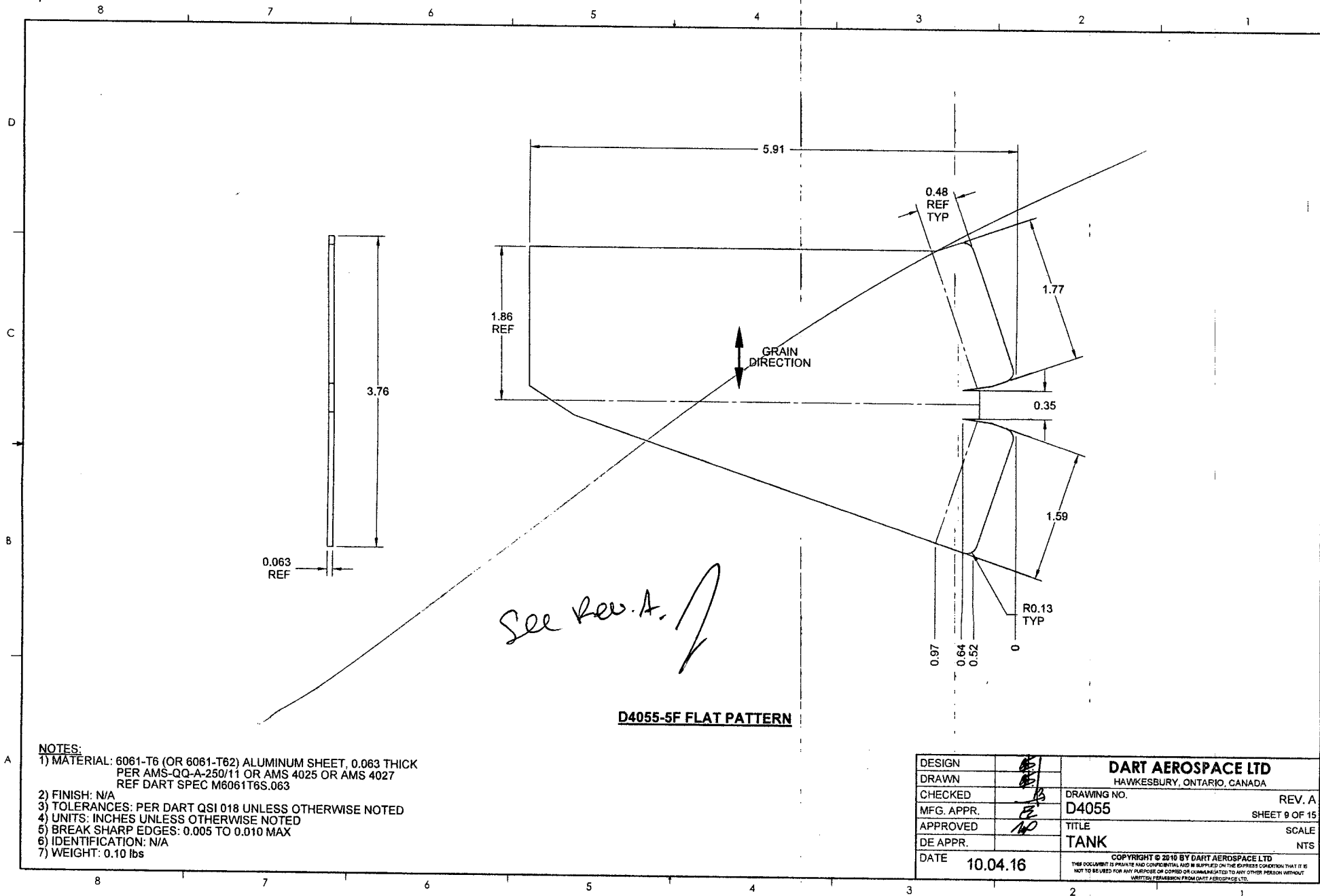
See Rev. A

D4055-5 UPPER CUT OUT

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 8 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

Dart Aerospace Ltd

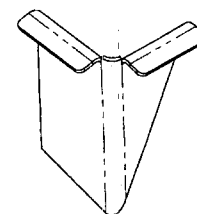
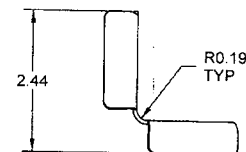
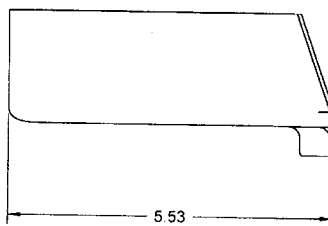
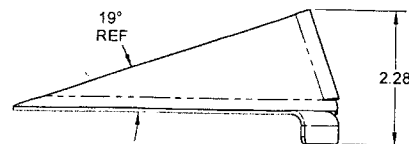
W/O: .		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		change are 2.050" was removed. change Angle in part. measurement unstable @ Dart.	Acceptable	1007-06		1007-06	10/24/22

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: _____ Date: 1007-08

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Parts have changed from PA1 to Rev A		Red tag all PA1 Parts. N/A parts confirm to Rev A				10/24/22

NOTE: Date & initial all entries



D4055-5 UPPER CUT OUT

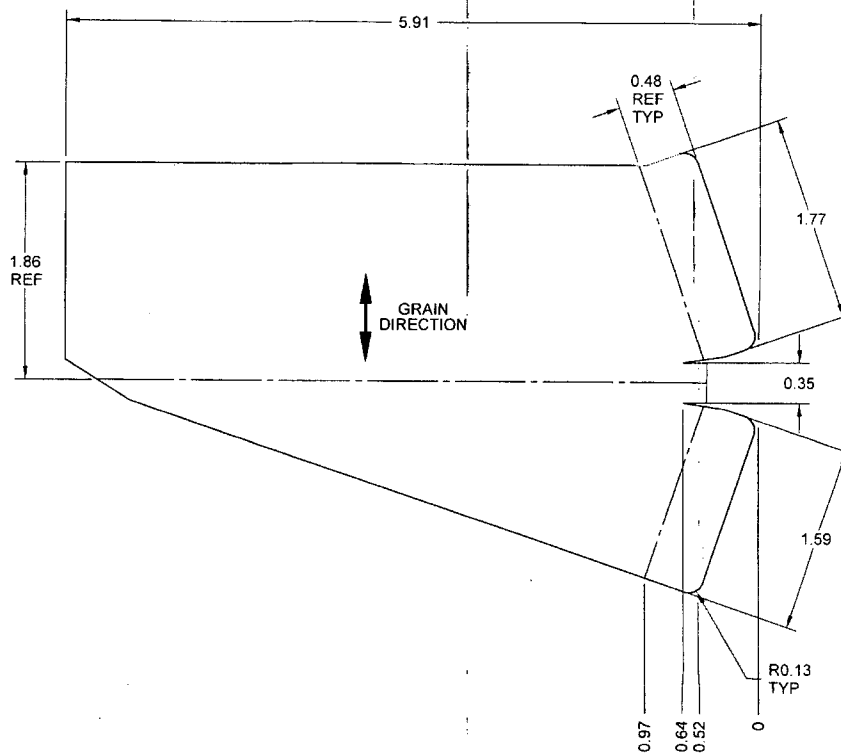
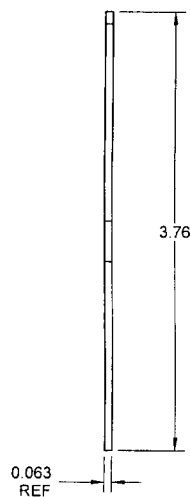
NOTES:

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- 2) FINISH: N/A
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

W1055555

RELEASED
2010-05-05
WD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 8 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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D4055-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG APPR.		D4055	SHEET 9 OF 15
APPROVED		TITLE	SCALE
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W/O 55959

RELEASED
2010-05-05
NP